



Product Information Flyer

DESCRIPTION

CIMTECH[®] 400 with MSL[®] is a clear, water-based synthetic metalworking fluid.

APPLICATION

CIMTECH[®] 400 with MSL[®] was designed for cast iron, carbon steels, high speed steel, high alloy steel, and stainless steels. It is not recommended for use on magnesium.

For moderate to heavy-duty operations.

FEATURES & BENEFITS

VERSATILE:

Wide range of machining capabilities varying from high-speed to such slow-speed operations. Displays good grinding capabilities in G-Ratios. Very low foaming with the use of silicone antifoam.

TOOL LIFE:

Allows high speeds and feeds to increase production. Reduces heat in the chip formation process. Provides excellent cooling properties resulting in more precise part geometry.

SETTLING PROPERTIES:

Effectively settles cast iron and steel fines, preventing recirculation of finish-marring swarf and clogging lines.

MICROBIAL and CORROSION CONTROL:

Greatly reduces odor problems even in individual machines. Gives longer product life. Provides excellent corrosion protection for ferrous metals.

CLEANLINESS:

Less residue buildup in low flow and splash zones than with other synthetics. Has good washing action to keep machine tools clean. Product leaves soft liquid film that is easily rinsed off parts for post-machining operations. Rejects tramp oil.

RECOMMENDED STARTING DILUTIONS

CIMTECH® 400 with MSL® is to be mixed with water for use. Always add concentrate to water. Add no other materials to the concentrate or mix unless approved by your CIMCOOL® District Manager.

Grinding	4% - 10%	(1:25 to 1:10)
Machining	4% - 10%	(1:25 to 1:10)

CONCENTRATION

BCG Titration, Total Alkalinity, CIMCHEK™ Test Strip or Refractometer can be used.

The Refractometer Factor is 2.3

Multiply the scale reading obtained on your CIMCOOL® Refractometer by this factor to obtain the mix concentration in percent. Calibrate the refractometer so that it reads 0.0 with water before testing the sample mix. Remove gross contaminants from the sample mixes before testing.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES:

Physical State: Liquid

Solubility in water: 100% miscible

Viscosity (SUS) @ 100°F: 45

pH Concentrate: 9.6

Total Chlorine/Chloride, wt%: 0.0/<50ppm

Silicones: None

Appearance and Odor: Clear/Chemical

Weight, lb/gal, 60°F (15.6 °C): 8.8

Flash Point /Sp.Gr./Boiling Point: SEE MSDS

pH Mix 5%, Typical Operating: 9.1

Total Sulfur, wt%: 0.0

HANDLING and STORAGE

If frozen, product separates. Thaw completely at room temperature and stir thoroughly before use. Inside storage is recommended.

SAFETY DATA SHEET

Available at www.cimcool.com

For additional information refer to its OSHA MSDS, website or contact your local CIMCOOL TECHNICAL SPECIALIST OR DISTRICT MANAGER, or you may contact CIMCOOL® Technical Services at 1-513-458-8199.

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